

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 561 612 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:
30.07.1997 Bulletin 1997/31

(51) Int Cl.⁶: **D01D 5/32, D01D 5/098,
D01D 4/02**

(21) Application number: **93301981.2**

(22) Date of filing: **16.03.1993**

(54) **Spinneret device for conjugate melt-blow spinning**

Spinnvorrichtung für Schmelzblaspinnen von Verbundfäden

Dispositif pour le filage par fusion-soufflage de fibres conjuguées

(84) Designated Contracting States:
DE DK FR GB IT

(30) Priority: **17.03.1992 JP 60512/92**

(43) Date of publication of application:
22.09.1993 Bulletin 1993/38

(73) Proprietor: **Chisso Corporation**
Osaka-shi Osaka-fu (JP)

(72) Inventors:
• **Terakawa, Taiju**
Yasu-gun, Shiga-ken (JP)

• **Nakajima, Sadaaki**
Kurita-gun, Shiga-ken (JP)

(74) Representative: **Ruffles, Graham Keith et al**
MARKS & CLERK,
57-60 Lincoln's Inn Fields
London WC2A 3LS (GB)

(56) References cited:
EP-A- 0 138 549 EP-A- 0 138 556
US-A- 3 981 650 US-A- 5 190 812

• **PATENT ABSTRACTS OF JAPAN vol. 15, no. 60**
(C-805)13 February 1991 & JP-A-02 289 107
(KURARAY CO LTD) 29 November 1990

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent granted. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

EP 0 561 612 B1

Description

BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to a spinneret device for conjugate melt-blow spinning. More particularly it relates to a spinneret device for side-by-side type conjugate melt-blow spinning wherein two kinds of spinning dopes are melt-extruded from spinning nozzles to form side-by-side conjugate fibers, followed by blown-spinning the extruded unstretched fibers by means of a high speed gas current. Microfine fibers obtained by means of such a spinning device are processed into a web-form product, a non-woven fabric or a molded product and used for a mask, a filter for precision filtration, a battery separator, a hygienic material, a thermal insulant, etc.

Description of the Prior Art

The so-called melt-blow spinning wherein a thermoplastic synthetic resin is melt-extruded from spinning nozzles followed by spouting a high temperature gas at a high speed from clearances provided on both sides of the spinning nozzles onto the extruded unstretched fibers to effect blow-spinning, makes it possible to obtain microfine fibers such as those having a fiber diameter of 10 μm or less. Since spinning of fibers and production of a non-woven fabric are carried out successively, the above process is advantageous for producing a non-woven fabric of microfine fibers.

There are two ways for a melt-blow spinning, one of which is by means of non-conjugate fibers and the other is by means of conjugate fibers.

As to the melt-blow spinning of non-conjugate fibers, its device and spinning process are disclosed in Industrial and Engineering Chemistry, Vol. 48, No. 8, pp 1342-1346, 1956. Japanese patent application laid-open No. Sho 50-46972 and Japanese patent application laid-open No. Sho 54-134177 disclose a process wherein spinning is carried out while decomposing polymer or while keeping the spinning conditions such as the apparent viscosity, extrusion temperature, etc. of polymer within specified critical ranges, along with an apparatus therefor. However, the above-mentioned references do not disclose any spinning of conjugate fibers.

As to the so-called conjugate melt-blow spinning directed to conjugate fibers, Japanese patent application laid-open No. Sho 60-99057 and Japanese patent application laid-open No. Sho 60-99058 disclose a spinneret device for side-by-side conjugate melt-blow spinning, provided with conduits for introducing two kinds of polymers from the respective extruders therefor, into holes for combining conjugate components of the polymers, a spinning nozzles and an air-orifice, and a spinning process. According to these publications, it has

been regarded as possible to produce microfine fibers according to side-by-side type conjugate, melt-blow spinning process, even in combinations of heterogeneous polymers such as polyester/polypropylene, nylon 6/polypropylene, etc. as conjugate components.

In the spinneret device and the production process of conjugate fibers disclosed in the above two publications, it has been regarded that viscosities of heterogeneous polymers passing through the die should be generally similar, and can be achieved by controlling the temperature and retention time inside the extruder, composition of polymer, etc. Namely, in the production process, only when the heterogeneous polymers reach a spinning nozzles in a state where the respective extrusion temperatures and retention times have been controlled so that the respective viscosities have become almost equal, and also flow through the inside of the spinneret while retaining the balance between the respective viscosities, the polymers can form a conjugate mass which is then extruded through nozzles of the spinneret without any notable turbulence or break at the conjugate portions to form conjugate blown fibers. However, according to such a spinneret device, it is possible to obtain uniform conjugate melt-blown fibers only when the temperature and retention time inside an extruder and the composition of the polymers, etc. are controlled precisely while employing a relatively small spinneret which retention time is short, without taking productivity into consideration. Namely, when a spinneret device having a commercial productivity is taken into consideration, the following problems occurs. When a viscosity difference has occurred between the respective melted polymers due to the variation in the molecular weights of the polymers, themselves, and a slight variation in the extrusion temperatures, then turbulence of flow of the polymers melted inside the spinneret device occurs, it is impossible to obtain a uniform conjugate mass inside the cavity of the spinneret device, and hence it is impossible to form uniform, conjugate blown fibers. Further, even if the temperature inside the extruder might have been precisely controlled so as to maintain the viscosities of the polymers at definite values, when a large spinneret is used for productivity, polymers having different fluidities flow through the spinneret kept at the same temperature, so that the retention time inside the spinneret device is prolonged and hence the viscosity balance is broken due to the difference of fluidities of the polymers to make it impossible to form uniform, conjugate blown fibers, and yet the fineness unevenness of the resulting fibers increases.

BRIEF DESCRIPTION OF THE DRAWING (Prior Art)

Fig. 17 shows the front, cross-sectional, schematic view of a conventional spinneret device for conjugate melt-blow spinning.

Fig. 18 shows a side, cross-sectional, schematic view of a conventional spinneret device for conjugate

melt-blow spinning.

Fig. 19 shows a front, cross-sectional, schematic view of a conventional spinneret device for conjugate melt-blow spinning, having a circular pipe part.

Japanese patent application laid-open No. Hei 2-289107 discloses a side-by-side type, conjugate, melt-blow spinneret device provided with a slender groove-form, confluent resin flow-controlling part 24 having a defined ratio of length to thickness in the length direction of the spinneret, engraved at the bottom part of the nozzle plate 5 in the length direction, nozzle plate 5 having spinning holes 15 engraved at the above bottom part, and separating plates 4 for separating two kinds of melted resins, provided in the cavity of the device (see Figs. 17 and 18). Further, the above publication also discloses a spinneret having a circular pipe part 25 for inserting a mixer into the bottom of the confluent resin flow-controlling part 23 (see Fig. 19). According to the device, the engraved, confluent resin flow-controlling part has the defined ratio of length to thickness in the length direction of the spinneret, therefore even when spinning melted resins which viscosities are somewhat different with each other are used as the first component and the second component of the conjugate fibers, the conjugate ratio, the fineness unevenness, etc. are somewhat improved, as compared with the prior art of the above publications, but since any mechanism for a uniform confluence of conjugate components and for a uniform distribution of these components corresponding to the respective spinning nozzles are not provided, the above-mentioned problems have not yet been solved.

As described above, in any of the above prior art, no consideration has been taken about a uniform confluence mechanism and a uniform distribution mechanism of conjugate components directed to all of the individual spinning nozzles.

SUMMARY OF THE INVENTION

The object of the present invention is to provide a spinneret device for side-by-side, conjugate melt-blow spinning, which can correspond to combinations of various kinds of heterogeneous polymers and yet be uniform in the conjugate state such as a conjugate ratio between extruded single fibers, a proportion of peripheral percentages of both the components in the fiber cross-section, etc. and also be uniform in the fineness of the fiber. Another object of the present invention is to provide a spinneret device which does not require an exchange of nozzle plate even in the case of combinations of polymers inferior in the conjugate state, and can obtain fibers having a good conjugate state and a uniform fineness from various kinds of polymers only by exchange of a separating plate which price is low. Still another object is to provide a spinneret device having a large width of spinneret and a superior productivity.

The present invention has the following constitu-

tions:

(1) A spinneret device for side-by-side conjugate melt-blow spinning, provided with a spinning resins-feeding plate 2 having spinning resins-introducing grooves for introducing two kinds of spinning resins into distributing grooves of a distributing plate 3, respectively engraved therein; the distributing plate 3 having distributing grooves for distributing the spinning resins fed from the spinning resins-feeding plate 2; a nozzle plate 5 having a cavity 13 for receiving a separating plate 4, engraved on the back surface thereof, and also having holes 14 for introducing a conjugate component and spinning nozzles 15 bored successively on the bottom surface X of the cavity 13 thereof; a separating plate 4 having its bottom part engraved so that confluent grooves 17 for combining the above-mentioned different spinning resins may intersect the length direction of the grooves and also the confluent grooves 17 may be positioned on the central axis of the spinning nozzles 15; and a clearance for spouting a gas, provided around the nozzle plate 5 and toward the exit of the spinning nozzles 15.

2. A spinneret device for side-by-side, conjugate melt-blow spinning according to item 1, wherein the distributing grooves of the distributing plate 3 are engraved in the length direction of the back surface of the distributing plate 3; distributing holes for leading the spinning resins into grooves 13 for receiving the spinning resins, of the nozzle plate 5 are bored in the distributing grooves; partitioning walls are formed between the respective confluent grooves 17 of the separating plate 4; and the clearance for spouting a gas is formed between the nozzle plate 5 and a plate 6 for controlling the clearance for a gas, provided around the nozzle plate 5.

3. A spinneret device for side-by-side conjugate melt-blow spinning according to item 1 or item 2, wherein the bottom surface K of the walls for partitioning the confluent grooves of the separating plate 4 is closely contacted to the bottom surface X of the cavity of the nozzle plate 5.

4. A spinneret device for side-by-side conjugate melt-blow spinning according to item 1 or item 2, wherein a narrow clearance D_1 is provided between the bottom surface K of the walls for partitioning the confluent grooves of the separating plate 4 and the bottom surface X of the cavity of the nozzle plate 5 and D_1 is smaller than the width W_3 of the grooves 12 for controlling the pressure of the spinning resins.

5. A spinneret device for side-by-side conjugate melt-blow spinning according to item 1 or item 2, wherein a narrow clearance D_1 is provided between the bottom surface K of the walls for partitioning the confluent grooves of the separating plate 4 and the bottom surface X of the cavity of the nozzle plate,

and the D_1 is smaller than either of the width W_3 of the grooves 12 for controlling the pressure of the spinning resins and the depth D_2 of the grooves 17.

6. A spinneret device for side-by-side conjugate melt-blow spinning according to item 5, wherein the depth D_2 of the grooves of the separating plate 4 is smaller than the width W_3 of the grooves 12 for controlling the pressure of the spinning resins.

BRIEF DESCRIPTION OF THE DRAWINGS OF THE INVENTION

Fig. 1 shows a front, schematic, cross-sectional view of the spinneret device for conjugate melt-blow spinning.

Fig. 2 shows an enlarged, cross-sectional view of the lower part of the nozzle plate of Fig. 1.

Figs. 3 and 4 each show an enlarged, cross-sectional view of the side surface of the separating plate for illustrating the grooves for combining different dopes.

Figs. 5 and 6 each show an enlarged, cross-sectional view of the separating plate for illustrating the confluent grooves having introducing grooves.

Fig. 7 shows an enlarged, cross-sectional side view of the side surface of the separation plate for illustrating the confluent grooves.

Figs. 8, 9, 10, 11, 12 and 13 each show a view for illustrating the relationship between the confluent grooves and the conjugate component-introducing hole.

Fig. 14 shows a view of the plane-back surface of the distributing plate.

Fig. 15 shows a view of the plane-back surface of the nozzle plate.

Fig. 16 shows a cross-sectional view of fibers.

Description of the symbols in the figures:

- 1: spinneret device for conjugate melt-blow spinning,
- 2: spinning melted resins-feeding plate,
- 3: distributing plate, 4: separating plate,
- 5: nozzle plate,
- 6: plate for controlling the clearance for gas,
- 7a: groove for introducing the spinning melted resin of component A,
- 7b: groove for introducing the spinning melted resin of component B,
- 8a: hole for distributing the component A,
- 8b: hole for distributing the component B,
- 9a: groove for distributing the component A,
- 9b: groove for distributing the component B,
- 10: filter, 11: bolt, 12: groove for controlling the pressure of spinning melted resins,
- 13: groove for receiving the spinning melted resins,
- 14: conjugate component-introducing hole,
- 15: spinning nozzle, 16: clearance for gas spouting,
- 17: confluent groove, 18: gas-introducing hole,
- 19: confluent grooves-partitioning wall,

- 20: introducing groove, 21: bolt hole,
- 22: top portion of separating plate,
- 23: cavity of nozzle plate,
- 24: part for controlling the confluent resin flow,
- 25: circular tube part, 26: conjugate fiber,
- 27: conjugate fiber, D_1 : a narrow clearance between the bottom face K of the confluent grooves-partitioning wall of separating plate and the bottom surface X of nozzle plate;
- D_2 : depth of confluent groove,
- W_1 : width of confluent groove,
- W_2 : diameter of conjugate component-introducing hole,
- W_3 : width of groove for controlling the pressure of spinning melted resin, L: length of confluent groove,
- K: bottom surface of confluent grooves-partitioning wall of separating plate,
- X: bottom surface of cavity of nozzle plate.

DESCRIPTION OF PREFERRED EMBODIMENTS

The embodiments of the present invention will be described below referring to the accompanying drawings.

Fig. 1 shows the front schematic cross-sectional view of the spinneret device for conjugate melt-blow spinning, and Fig. 2 shows the enlarged cross-sectional view of the lower part of the nozzle plate of Fig. 1.

This spinneret device is composed mainly composed of a plate 2 for feeding spinning melted resin A and B, having grooves 7a and 7b for introducing the resins, respectively, engraved therein; a distributing plate 3 for uniformly distributing the resins fed via the plate 2; a nozzle plate 5 having a cavity 13 for inserting a separating plate 4 mentioned below, engraved on the back surface thereof, and also having holes 14 for introducing conjugate components and a spinning nozzle 15 bored on the bottom surface X of the cavity 13; a separating plate 4 engraved so that, at the lower part of the plate, a confluent groove 17 for confluent combining the above spinning resins can intersect the length direction and also the confluent groove 17 can be present on the central axis of a spinning nozzle 15; and a clearance 16 for spouting a gas, formed toward the exit of the spinning nozzle 15, between the nozzle plate 5 and a plate 6 for controlling the clearance 16 for spouting a gas, provided outside the plate 5.

The plate 2 for feeding the spinning melted resin has grooves 7a and 7b for introducing the dope engraved in a slit form and the discharge ports thereof are engraved in a broad angle form so as to accord with the distributing grooves 9A and 9B of the distributing plate 3. The plate 2 for feeding the spinning resin may be of one member, but in the case of the instant embodiment, the plate is divided into three members of a left member, a central member and a right member as shown in Fig. 1 and these members are respectively fixed by bolts.

The distributing plate 3 has distributing grooves 9a and 9b engraved in the length direction, that is, in the front and rear directions as viewed in Fig. 1. Further, at the respective bottoms thereof, a number of distributing holes 8a and 8b are bored. Further, the distributing grooves 9a and 9b have filters 10 fitted therewith, and the bottoms of the distributing grooves also function as a support of the filters. The filters 10 may be provided either on the ventral surface of the spinning resin-discharging part of the distributing holes 8a and 8b or on the spinning resin-receiving port of the plate 2. Although the distributing plate 3 and a separating plate 4 mentioned below are fixed by bolt 11 in this embodiment, they may be of a solid structure.

The cavity of the nozzle plate 5 is separated into two parts (right and left parts as viewed in Fig. 2) by the separating plate 4 arranged in the cavity, to form the spinning resins-receiving grooves 13 of two rooms (see Fig. 1) and two narrow grooves 12 for controlling the pressure of the spinning resins, communicating with the grooves 13.

The upper surface of the nozzle plate 5 has a cavity for receiving a separating plate 4, engraved in the length direction, that is, in the front and rear directions as viewed in the figure, and the bottom surface X of the cavity bottom has conjugate component-introducing holes 14 and spinning nozzles 15 at the lower part of the holes 14.

In the above construction, the respective spinning melted resins of the components A and B extruded from two extruders reach the respective ports of the spinning melted resins-receiving parts (now shown) by means of two gear pumps (not shown), and are discharged into the respective spinning resins-introducing grooves 7a and 7b and reach the distributing grooves 9a and 9b of the distributing plate 3. The respective spinning resins pass through the respective distributing holes 8a and 8b and are discharged into the grooves 13 for receiving the spinning resins of the upper part of the nozzle plate 5. The respective spinning resins pass through the respective spinning resins-receiving grooves 13 and the grooves 12 for controlling the pressure of the spinning resins, and are combined in a confluent groove 17 at the lower part of the separating plate 4, followed by passing through the conjugate component-introducing hole 14 of the nozzle plate 5 and being spun through the spinning nozzle 15.

The bottom surface X of the cavity of the nozzle plate 5 is contacted closely to the bottom surface K of the confluent grooves-partitioning walls of the separating plate 4 mentioned below, as shown in Fig. 7, or both the surfaces are not contacted, but a narrow clearance D_1 is formed therebetween, as shown in Fig. 3. Further, when the nozzle plate 5 is cut so as to perpendicularly intersect its length direction, the resulting shape takes an inverted, equilateral triangle.

The above grooves 12 for controlling the pressure of the spinning resins refer to a clearance between the

side wall of a nearly V-form part at the lower part of the separating plate 4 and the side wall of the cavity of the nozzle plate 5, as shown in Figs. 1 and 2. The width W_3 of the controlling grooves 12 is preferably about 0.5 to 10 mm. If the width is too small, the transfer speed of the spinning resins is too high, so that viscosity unevenness occurs and the pressure variation in the confluent groove occurs; hence the conjugate state is inferior. To the contrary, if the width is too large, the transfer speed of the spinning resin is too low, so that an extraordinary thermal decomposition, carbonization, etc. of the spinning resin occur.

The diameter W_2 of the conjugate component-introducing hole 14 bored in the nozzle plate 5 is preferably about 0.3 to 5 mm, and the diameter of the spinning nozzle is preferably about 0.1 to 1.5 mm. Further, the spinning nozzles are preferred to be bored at a pitch of about 0.5 to 10 mm.

The separating plate 4 is secured at its top part to the distributing plate 3 by bolts. In the separating plate 4, confluent grooves 17 are engraved at its lower part of the plate, in a plurality of rows, in the direction intersecting the length direction, that is, in the direction from the right to the left as viewed in Fig. 1. Between the respective confluent grooves 17, there are formed confluent grooves-partitioning walls 19, for example as shown in Fig. 3. The confluent grooves 17 are arranged in the number of one each one spinning nozzle 15 on the central axis of the respective spinning nozzles 15. The grooves 12 for controlling the pressure of the spinning resins formed by the clearance between the separating plate 4 and the nozzle plate 5 are extended in the length direction of the nozzle plate. Although the spinning resins flowing down through the grooves 12 may cause a pressure unevenness (flow quantity unevenness each spinning nozzle) over the length direction of the nozzle plate 5, which may cause conjugate ratio unevenness and fineness unevenness, the confluent grooves 17 prevent such conjugate unevenness and fineness unevenness from occurring.

The depth D_2 of the confluent grooves (see Fig. 3) is preferably about 0.1 to 5 mm and the width W_1 thereof is preferably about 0.3 to 5 mm. Further, the width W_1 of the confluent grooves 17 is preferred to be the same as the diameter W_2 of the conjugate component-introducing holes, but either of $W_1 > W_2$ (see Figs. 4 and 10) or $W_1 < W_2$ (see Fig. 9) may be employed. However, the proportion of W_1 and W_2 is preferably limited to 2:1 to 1:2. If the proportion is too small or too large, the conjugate ratio becomes either uneven. As to the relationship between the length L of the confluent grooves 17 and the diameter W_2 of the conjugate component-introducing hole 14, $L < W_2$ may be employed as shown in Fig. 11. The length L is preferred to be longer as far as the processing is possible. Further, as to the confluent grooves 17, the spinning resins-introducing inlet part thereof may be broader than the center part thereof, as shown in Fig. 13. Further, when a introducing groove 20

(see Fig. 6) is provided along with the confluent grooves 17, it is possible to more effectively prevent the conjugate ratio unevenness and the fineness unevenness from occurring. The width and the depth of the introducing groove 20 may be to the same extent as the width of the confluent grooves 17, and the depth and the length thereof may be to an extent of 2 to 30 mm. This introducing groove 20 may be extended from both the end parts of the confluent grooves 17 upward of the wall of the separating plate, as shown in Figs. 5 and 6. The groove 20 is not limited to the vicinity of the lower part of the separating plate 4, but it may be engraved extending as far as the spinning resins-receiving grooves 13, for example.

The separating plate 4 is easy to subject the confluent grooves 17 to be processed for engraving and possible to be manufactured at a low cost. Hence, it is possible to provide several separating plates each being different in the dimensions of the confluent grooves 17, exchange only the separating plate 4 without exchanging an expensive nozzle plate 5, carry out trial spinning to select a separating plate affording an optimum conjugate state corresponding to the respective spinning resins.

In the present spinneret device, the bottom surface K of the confluent grooves-partitioning wall 19 of the separating plate 4 may be contacted closely to the bottom surface X of the cavity of the nozzle plate 5, as shown in Fig. 7, but a narrow clearance D_1 may be provided between K and X, as shown in Fig. 3. When the bottom surface (K) is contacted closely to the bottom surface X ($D_1=0$), it is advantageous for separating the respective spinning nozzles, but liable to injure the bottom surface K and the bottom surface X, and since these bottom surfaces are close to the spinning nozzles, the injuries of these surfaces have a large influence upon the flow of the spinning resins, to cause a fineness unevenness of fibers. In the case of providing the narrow clearance D_1 , the D_1 is preferred to be smaller than the width W_3 of the grooves for controlling the pressure of the spinning resins. Further, the D_1 is more preferred to be smaller than either of W_3 and D_2 (see Figs. 1 and 2). If D_1 is larger than W_3 , a high pressure is applied onto the bottom part of the cavity of the nozzle plate (the inlet of the conjugate component-introducing hole 14), a large pressure drop is liable to occur at the part, resulting in the variation of the conjugate ratio and the fineness unevenness of fibers.

When spinning is carried out using the spinneret device of the present invention, two kinds of the spinning resins are combined uniformly in side-by-side form in the respective confluent grooves arranged just above the spinning nozzles 15, pass through the conjugate component-introducing hole 14 and are led to the spinning nozzles 15. Thus, when the viscosity difference between two kinds of the components is relatively large, or even when the viscosity unevenness, the spinning temperature unevenness, etc. occur to a certain extent

in the cavity part of the nozzle plate 5, microfne fibers can be obtained which are uniform in the conjugate ratio, the cross-sectional, peripheral percentages of the respective components in the fiber cross-section, etc. and yet small in the fineness unevenness of the fiber.

The unstretched fibers extruded from the spinning nozzles 15 are stretched and at the same time cut into short fiber form, by spouting a high temperature and high pressure gas introduced from the gas-introducing hole 18 through a clearance 16 for gas spouting, followed by being collected in the form of a microfne fiber web by a collecting means arranged at below the nozzle plate 15. As the spouting gas, an inert gas such as air, nitrogen gas, etc. is used, and its temperature may be about 100° to 500°C and its pressure may be about 0.5 to 6 Kg/cm². Further, the clearance 16 for the gas spouting may be arranged not only in one way as shown in Fig. 1, but also in two ways.

The cross-section of the thus obtained microfne fiber is typically shown in the form of a side-by-side type as shown by (26) and (27) in Fig. 16. The fibers are used for various use applications, as they are, or by subjecting them to modification treatment such as corona discharge treatment, hydrophilic nature-affording treatment, treatment with anti-fungus agent, etc. or by blending them with other fibers, or in the form of a web or a non-woven fabric obtained by developing crimp by heating and/or by hot-melt adhesion of conjugate components of the fibers.

According to the spinneret device for conjugate melt-blow spinning of the present invention (items 1 to 3), since confluent grooves 17 are provided corresponding to the respective spinning nozzle 15 at the lower part of the separating plate 4, even when the viscosity unevenness, spinning temperature unevenness, etc. of the spinning resins occur to some extent at the cavity part of the nozzle plate 5, microfne fibers can be obtained which are uniform in the composite ratio and the cross-sectional, peripheral percentages of the respective components in the fiber cross-section, and yet small in the fineness unevenness. Further, the separating plate 4 is easy to subject the confluent grooves to be processed for engraving and possible to be manufactured at a low cost. Hence, it is possible to provide several separating plates each being different in the dimensions of the confluent grooves, carry out trial spinning and easily arrange a separate plate affording the optimum conjugate state corresponding to the respective spinning resins. Further, it is possible to arrange a nozzle plate having a broad width and a superior productivity. Further, according to the present invention of items 4 and 5, a device wherein the separating plate 4 and the nozzle plate 5 are arranged in a narrow clearance D_1 , has an effectiveness that, in addition to the above effectiveness, either of the bottom of the nozzle plate 5 and the lower part of the separating plate 4 are not damaged, so that the life of the device can be prolonged.

Claims

1. A spinneret device for side-by-side conjugate melt-blow spinning, provided with a spinning resins-feeding plate (2) having spinning resins-introducing grooves for introducing two kinds of spinning resins into distributing grooves of a distributing plate (3) respectively engraved therein; the distributing plate (3) having distributing grooves for distributing the spinning resins fed from the spinning resins-feeding plate (2); a nozzle plate (5) having a cavity (13) for receiving a separating plate (4) engraved on the back surface thereof, and also having holes (14) for introducing a conjugate component and spinning nozzles (15) bored successively on the bottom surface (X) of the cavity (13) thereof; characterised by the separating plate (4) having its bottom part engraved so that confluent grooves (17) for combining the above-mentioned different spinning resins may intersect the length direction of the grooves and also the confluent grooves (17) may be positioned on the central axis of the spinning nozzles (15); and a clearance for spouting a gas, provided around the nozzle plate (5) and toward the exit of the spinning nozzles (15).
2. A spinneret device for side-by-side, conjugate melt-blow spinning according to claim 1, wherein the distributing grooves of the distributing plate (3) are engraved in the length direction of the back surface of the distributing plate (3); distributing holes for leading the spinning resins into grooves (13) for receiving the spinning resins, of the nozzle plate (5) are bored in the distributing grooves; partitioning walls are formed between the respective confluent grooves (17) of the separating plate (14); and the clearance for spouting a gas is formed between the nozzle plate (5) and a plate (6) for controlling the clearance for a gas, provided around the nozzle plate (5).
3. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 1, wherein the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate 4 is closely contacted to the bottom surface (X) of the cavity of the nozzle plate (5).
4. A spinneret device for side-by-side, conjugate melt-blow spinning according to claim 1, wherein a narrow clearance (D1) is provided between the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate (4) and the bottom surface (X) of the cavity of the nozzle plate (5) and (D1) is smaller than the width (W3) of the grooves (12) for controlling the pressure of the spinning resins.
5. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 1, wherein a narrow clearance (D1) is provided between the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate (4) and the bottom surface (X) of the cavity of the nozzle plate, and the (D1) is smaller than either of the width (W3) of the grooves (12) for controlling the pressure of the spinning resins and the depth (D2) of the grooves (17).
6. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 5, wherein the depth (D2) of the combining grooves of the separating plate (4) is smaller than the width (W3), of the grooves (12) for controlling the pressure of the spinning resins.
7. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 2, wherein the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate (4) is closely contacted to the bottom surface (X) of the cavity of the nozzle plate (5).
8. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 2, wherein a narrow clearance (D1) is provided between the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate (4) and the bottom surface (X) of the cavity of the nozzle plate (5) and (D1) is smaller than the width (W3) of the grooves (12) for controlling the pressure of the spinning resins.
9. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 2, wherein a narrow clearance (D1) is provided between the bottom surface (K) of the walls for partitioning the confluent grooves of the separating plate (4) and the bottom surface (X) of the cavity of the nozzle plate, and the (D1) is smaller than either of the width (W3) of the grooves (12) for controlling the pressure of the spinning resins and the depth (D2) of the grooves (17).
10. A spinneret device for side-by-side conjugate melt-blow spinning according to claim 9, wherein the depth (D2) of the grooves of the separating plate (4) is smaller than the width (W3) of the grooves (12) for controlling the pressure of the spinning resins.

Patentansprüche

1. Spinnendüsenvorrichtung für das Schmelzblasspinnen von Seite-an-Seite-Bikomponentenfasern, die ausgerüstet ist mit: einer Spinnharzzuführplatte (2), die Spinnharzzuführungsnuten für das Zuführen von zwei Arten von Spinnharzen in die Verteilungs-

- nuten einer Verteilungsplatte (3), die darin entsprechend eingraviert sind, aufweist; der Verteilungsplatte (3), die die Verteilungsnuten für das Verteilen der Spinnharze aufweist, die von der Spinnharzuführplatte (2) zugeführt werden; einer Düsenplatte (5), die einen Hohlraum (13) für das Aufnehmen einer Trennplatte (4), der in deren Rückseite eingraviert ist, und ebenfalls die Löcher (14) für das Zuführen eines Bikomponentenharzes und die Spindüsen (15) aufweist, die nacheinander in die Bodenfläche (X) des Hohlraumes (13) gebohrt sind; gekennzeichnet dadurch, daß die Trennplatte (4) einen Bodenabschnitt aufweist, der so graviert wurde, daß zusammenlaufende Nuten (17) für das Vereinigen der vorangehend erwähnten unterschiedlichen Spinnharze die Längsrichtung der Nuten schneiden können, und daß ebenfalls die zusammenlaufenden Nuten (17) auf der Mittelachse der Spindüsen (15) angeordnet werden können; und daß ein Zwischenraum für das Herausdrücken eines Gases um die Düsenplatte (5) herum und in Richtung des Austrittes der Spindüsen (15) vorhanden ist.
2. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 1, bei der die Verteilungsnuten der Verteilungsplatte (3) in der Längsrichtung der Rückseite der Verteilungsplatte (3) eingraviert sind; die Verteilungslöcher für das Führen der Spinnharze in die Nuten (13) für das Aufnehmen der Spinnharze von der Düsenplatte (5) in die Verteilungsnuten gebohrt sind; Trennwände zwischen den entsprechenden zusammenlaufenden Nuten (17) der Trennplatte (4) gebildet werden; und der Zwischenraum für das Herausdrücken eines Gases zwischen der Düsenplatte (5) und einer Platte (6) gebildet wird, um den Zwischenraum für ein Gas zu regulieren, der um die Düsenplatte (5) herum vorhanden ist.
 3. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 1, bei der die Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) einen engen Kontakt mit der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) aufweist.
 4. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 1, bei der ein schmaler Zwischenraum (D1) zwischen der Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) und der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) vorhanden ist, und (D1) kleiner ist als die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze.
 5. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 1, bei der ein schmaler Zwischenraum (D1) zwischen der Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) und der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) vorhanden ist, und (D1) kleiner ist als sowohl die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze als auch die Tiefe (D2) der Nuten (17).
 6. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 5, bei der die Tiefe (D2) der sich vereinigenden Nuten der Trennplatte (4) kleiner ist als die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze.
 7. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 2, bei der die Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) einen engen Kontakt mit der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) aufweist.
 8. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 2, bei der ein schmaler Zwischenraum (D1) zwischen der Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) und der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) vorhanden ist, und (D1) kleiner ist als die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze.
 9. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 2, bei der ein schmaler Zwischenraum (D1) zwischen der Bodenfläche (K) der Wände für das Trennen der zusammenlaufenden Nuten der Trennplatte (4) und der Bodenfläche (X) des Hohlraumes der Düsenplatte (5) vorhanden ist, und (D1) kleiner ist als sowohl die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze als auch die Tiefe (D2) der Nuten (17).
 10. Spindüsenvorrichtung für das Schmelzblas-spinnen von Seite-an-Seite-Bikomponentenfasern nach Anspruch 9, bei der die Tiefe (D2) der Nuten der Trennplatte (4) kleiner ist als die Breite (W3) der Nuten (12) für das Regulieren des Druckes der Spinnharze.

Revendications

1. Dispositif de filage pour le filage par fusion-souffla-

- ge de fibres conjuguées côte à côte, comportant une plaque d'amenée des résines de filage (2), avec des rainures d'introduction des résines de filage, pour introduire deux types de résines de filage dans les rainures de distribution d'une plaque de distribution (3), qui y sont respectivement gravées; la plaque de distribution (3) comportant des rainures de distribution pour distribuer les résines de filage amenées par la plaque d'amenée des résines de filage (2); une plaque de buses (5) comportant une cavité (13) pour recevoir une plaque de séparation (4), gravée sur la surface arrière correspondante, et comportant également des trous (14) pour introduire un composant conjugué, et des buses de filage (15) alésées successivement sur la surface inférieure (X) de la cavité (13) correspondante; caractérisé par une plaque de séparation (4) comportant une partie inférieure gravée, de sorte que les rainures de confluence (17) destinées à combiner les différentes résines de filage ci-dessus peuvent couper la direction de la longueur des rainures, les rainures de confluence (17) pouvant en outre être positionnées sur l'axe central des buses de filage (15); un passage permettant le jaillissement d'un gaz étant agencé autour de la plaque de buses (5) et en direction de la sortie des buses de filage (15).
2. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 1, dans lequel les rainures de distribution de la plaque de distribution (3) sont gravées dans la direction de la longueur de la surface arrière de la plaque de distribution (3); des trous de distribution pour guider les résines de filage dans les rainures (13) destinées à recevoir les résines de filage de la plaque de buses (5) étant alésés dans les rainures de distribution; des parois de séparation étant formées entre les rainures de confluence respectives (17) de la plaque de séparation (4); et un passage pour faire jaillir un gaz étant formé entre la plaque de buses (5) et une plaque (6) pour régler le passage d'un gaz, agencé autour de la plaque de buses (5).
 3. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 1, dans lequel la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) est en contact étroit avec la surface inférieure (X) de la cavité de la plaque de buses (5).
 4. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 1, dans lequel un passage étroit (D1) est agencé entre la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) et de la surface inférieure (X) de la cavité de la plaque de buses (5), le passage (D1) étant plus petit que la largeur (W3) des rainures (12) destinées à régler la pression des résines de filage.
 5. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 1, dans lequel un passage étroit (D1) est agencé entre la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) et la surface inférieure (X) de la cavité de la plaque de buses, le passage (D1) étant plus petit que la largeur (W3) des rainures (12) servant à régler la pression des résines de filage et la profondeur (D2) des rainures (17).
 6. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 5, dans lequel la profondeur (D2) des rainures convergeantes de la plaque de séparation (4) est plus petite que la largeur (W3) des rainures (12) destinées à régler la pression des résines de filage.
 7. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 2, dans lequel la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) est en contact étroit avec la surface inférieure (X) de la cavité de la plaque de buses (5).
 8. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 2, dans lequel un passage étroit (D1) est agencé entre la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) et la surface inférieure (X) de la cavité de la plaque de buses (5), le passage (D1) étant plus petit que la largeur (W3) des rainures (12) servant à régler la pression des résines de filage.
 9. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 2, dans lequel un passage étroit (D1) est agencé entre la surface inférieure (K) des parois de séparation des rainures de confluence de la plaque de séparation (4) et la surface inférieure (X) de la cavité de la plaque de buses, le passage (D1) étant plus petit que la largeur (W3) des rainures (12) servant à régler la pression des résines de filage et que la profondeur (D2) des rainures (17).
 10. Dispositif de filage pour le filage par fusion-soufflage de fibres conjuguées côte à côte selon la revendication 9, dans lequel la profondeur (D2) des rainures de la plaque de séparation (4) est plus petite que la largeur (W3) des rainures (12) servant à régler la pression des résines de filage.

FIG. 1

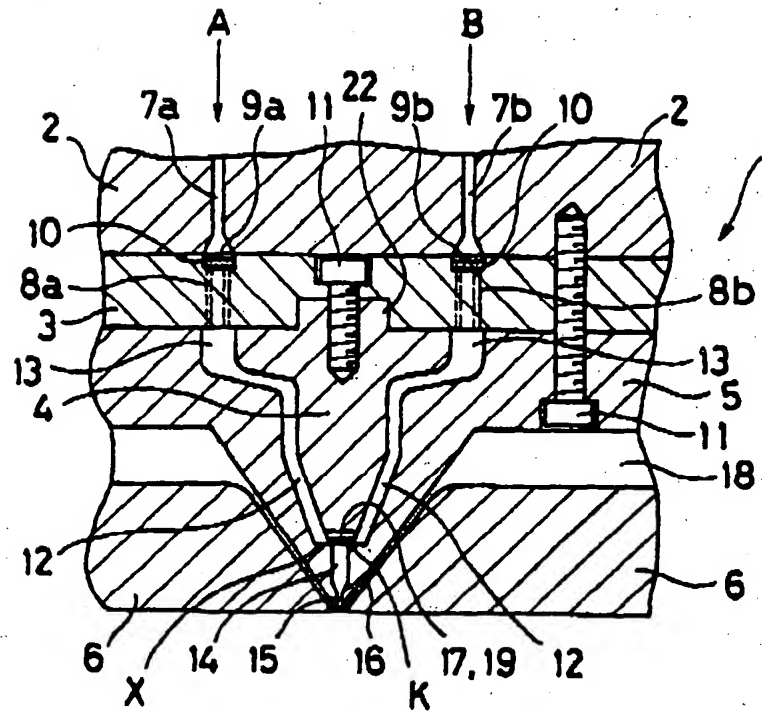


FIG.2

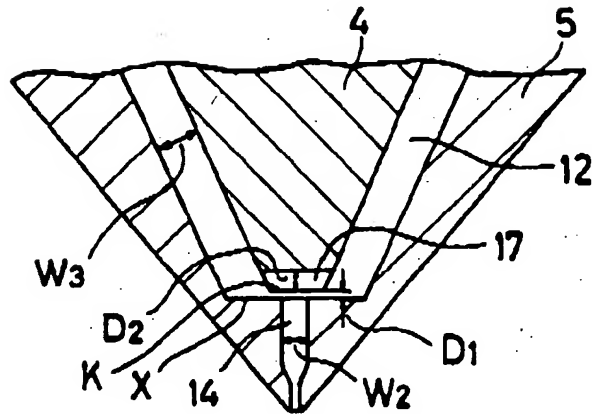


FIG.3

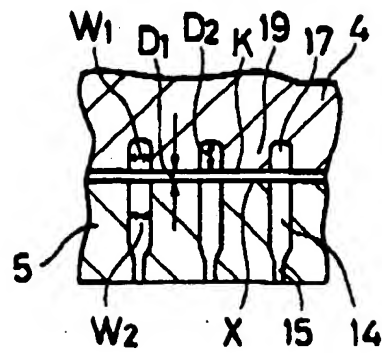


FIG.4

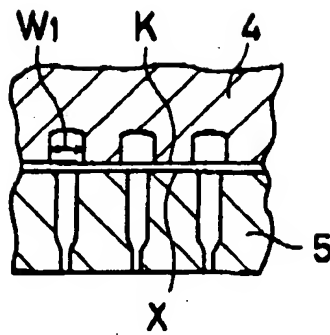


FIG. 5

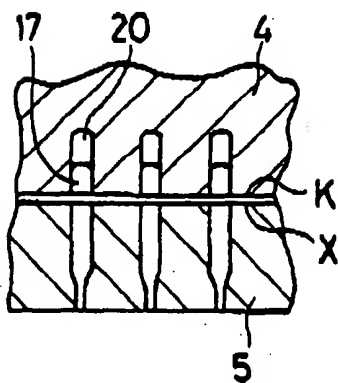


FIG. 6

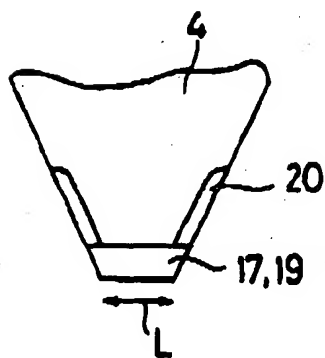


FIG. 7

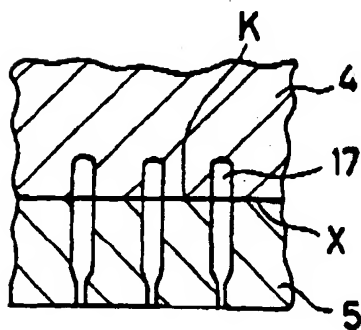


FIG. 8

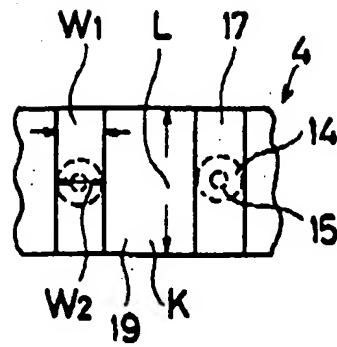


FIG. 9

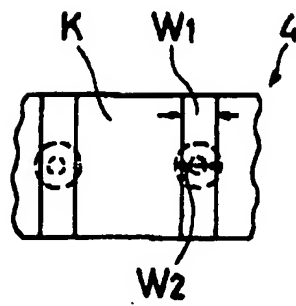


FIG. 10

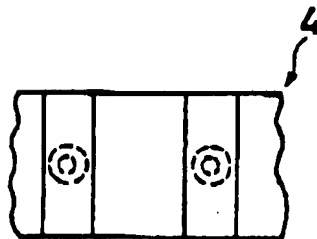


FIG.1 1

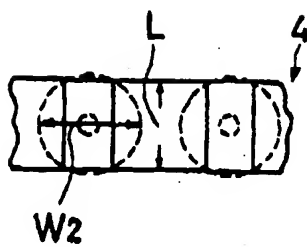


FIG.1 2

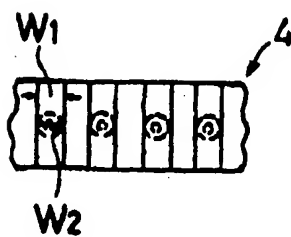


FIG.1 3

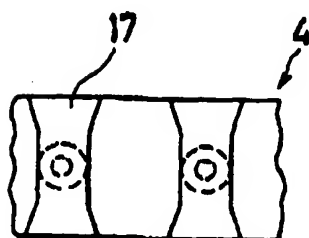


FIG. 1 4

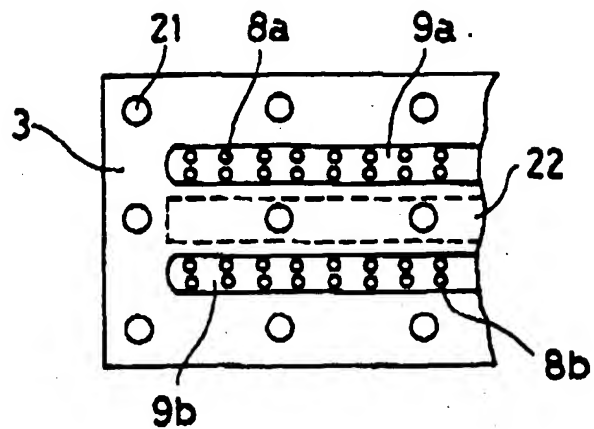


FIG. 1 5

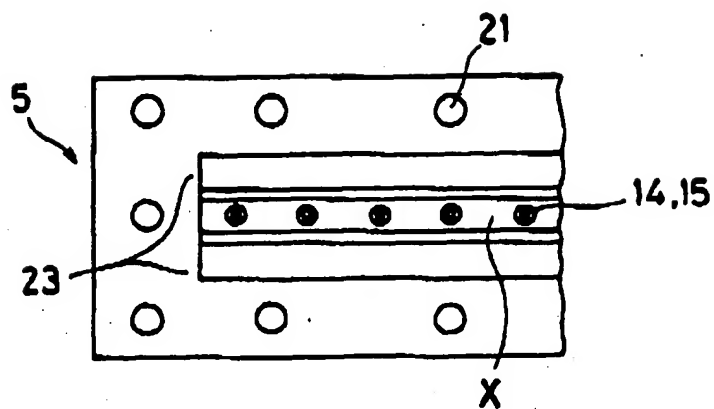


FIG. 1 6

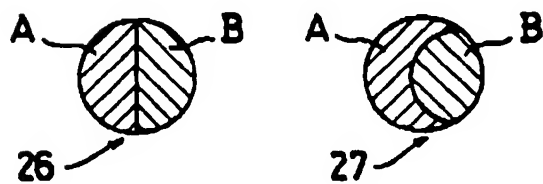


FIG. 1 7
(PRIOR ART)

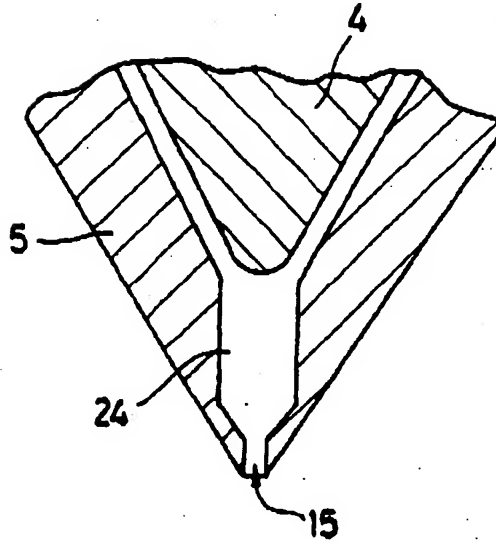


FIG. 1 8
(PRIOR ART)

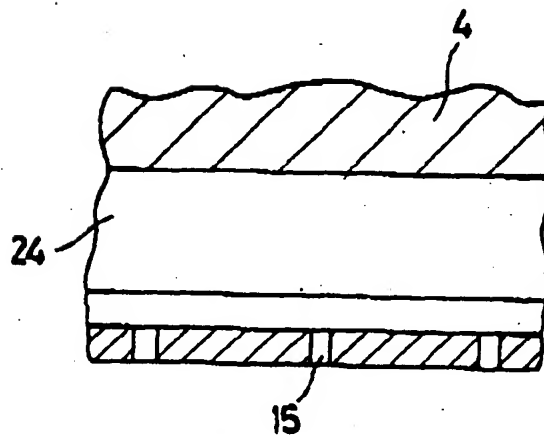


FIG. 19
(PRIOR ART)

